

**SUBSTITUTE ABSTRACT**

Frame members are joined in a mold without forming the intricate configuration on the end part of the frame members, and without using [the] joining members. A sash fits into a first fitting groove, which is formed on the mold. The side frame is fit into a second fitting groove, and the vertical frame is fit into the third fitting groove. Consequently, the sash, the side frame and the vertical frame are arranged to the mold. After fitting the sash, the side frame and the vertical frame are fit into the grooves, molten metal is poured into the mold until the sash, the side frame and the vertical frame are completely covered with the molten metal. After the molten metal is poured into the mold, it is cooled for a predetermined time and is removed from the mold after becoming hardened. Consequently, each end part of the sash, the side frame and the vertical frame are joined by being wrapped up in cast metal.